Work Orde September-23-13	er ID 107137 11:09:41 AM		*107	7137*				Page 1
Revision ID: tem Name:	D4001-3  Fitting  9/23/13  Start Qty:  9/23/13  Req'd Qty	: 469 15.0 A*	Accept	*N9000  Cust Item II  Customer:		)O*	Setup Start Stop	ונימו
Reference:	····	, 4				1	Run Start	48 IF 44
Approvals:	Process Plan: ML	J Date: 13-091-24	Tooling:	Da	te:			"NRT"
	QC:	Date:	SPC (Y/N):	Da	te:	. <del></del>	Stop	*NR2*
Sequence ID/ Work Center ID	Operation Description		Set Up/ Run Hours	Tool ID	Tool # Plar Cod	-	•	Reject Insp. Number Stamp
Draw Nbr	Revision Nbr				210000000000000000000000000000000000000			
D4001	A							
*100* Lathe Conv		<b>Memo</b> I-Turn as per dwg	0.00 0.00 (AS 9-89	13/09/30		10	Ø	·
	Г	DEBURR						
<sup>20</sup> *1ク <b>∩</b> *	QC2- Inspect	parts off machine FAI/FAIB	0.00 (SAA	13/09/30		10	ds	
QC Quality Control	N	Memo	0.00 9-89	, , , , , ,			<del></del>	
es, f		·						
<sup>30</sup> *13∩*	QC8- Inspect	parts - second check	0.00	AS 13/10	V01	lo	Ø	
QC	· • •	Memo	0.00			***************************************	·	The same of the sa

Quality Control

											DQA:	Dat	.e.	
NCR: Y	⁄es	/ No				WORK ORDER NON-C	100	NFORN	MANCE / UPDATE	,	QA Closed:	Dat	re.	
						DISPOSITION			AGA		PARTMENT		_	
Work Orde	er: _					DISPOSITION	_				rantiviciti,	, r ROCLSS		
Part N	-					Rework Scrap Use-as-is Work Order Update		Skid-tube Crosstube  Machining Small Fab  Thermoforming Finishing		II Fab	Water Jet Prod. Eng. Coor. Rec/Store/Packaging			Engineering Quality Other
NCR N	۱o. <u>-</u>					Work Order Update	]		Large Fab Comp	osite		Supplier		
Root			:		Descri	ption of work order update		Initial	Action	<del> </del>	Sign &			
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Description		Date	Verification	า	QC Inspector
Doc/Data									-					
Equip/Tooling							Ì							
Operator											i			
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Setup														
Other														
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Supplier				Ì							,		i	
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Landi					_	General		1			1	ſ	_	1
	-	Bending				Bend	$\vdash$	Grain		<u> </u>	Ovalized		_	Pressure/Forced
		Centre No	ot Concei	ntric to	o/s       _	BOM/Route	$\vdash$	Hardwa			Over/Under	1	_	Temperature/Cure
	<u> </u>	Cracks			· ·	Broken/Damaged	$\vdash$	1	on Incomplete	<u> </u>	Part incorre		—	Weld
	-	Crushed/	Crimped		<u> </u>	Burrs	$\vdash$	4	ions Incomplete/Unclear	<u> </u>	Part Lost/M	ssing		Wrong Stock Pulled
	$\vdash$	Cuffs			-	Contamination	_	Mainte		<u> </u>	Part Moved	Mana		
	Н	Heat Trea				Countersink	$\vdash$	Mislabe		$\vdash$	Positioned V			] <sub>0.6</sub>
	1 1	Inspection	n Strip in	Tube	1	Cut Too Short		Misread			Power Loss/	Surge [		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Page 2

September-23-1	3 11:09:41 2	AM									
Item ID: Revision ID:	D4001-3			Accept	*N900	040	100	<b>)*</b> s	Setup Star	IV	S1*
Item Name:	Fitting								Sto	<sup>p</sup> *N	S2*
Start Date:	9/23/13	Start Qty: 4.00 .	*4*		Cust Item 1	D:					
Required Date	: 9/23/13	<b>Req'd Qty:</b> 4.00	*4*		<b>Customer:</b>						
Reference:				·							
Approvals:	Process Pl	lan:	Date:	Tooling:	D	ate:		R	Run Stai	1/1	R1*
	QC:		Date:	SPC (Y/N):	D:	ate:			Sto	*N	R2*
Sequence ID/ Work Center I	I <b>D</b>	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
131		Chemical Conversion Coa	at per QSI005 4.1	0.00				4.0	-1	<b>a</b> 6	~ <b>^</b>
*131* HandFinish		Memo		0.00				<u> w</u>	-HO	13-10	<u>ل</u> ال
Hand Finishing		brush alodine ****do not	e as per dwg acid etch*****								
132		QC3- Inspect Part Finish		0.00							DAS 09
*132* QC Quality Control		Memo		0.00				_ (10)	)13-1	0.03	\ \Q\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\\
140		Identify as per dwg & Sto	ock Location: 572	43 0.00					126		
*140* Packaging		Memo		0.00				<u>10</u> x	( <b>166</b>	13-10	-3
Packaging											

										DQA:	Date	::
NCR: Y	es / N	0			WORK ORDER NON-C	O	NFORN	AANCE / UPI	DATE	QA Closed:	 Date	·•
					DISPOSITION				AGAINST DE	-		
Work Orde	er:				DISFOSITION			_	AGAINST DE	r Antivicia i	, r NOCE33	
	lo				Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		1	T	Descri	ption of work order update		nitial	Act	tion	Sign &		
Cause	Dat	e Step	Qty		or Non-conformance		ief Eng		ription	Date	Verification	QC Inspector
Doc/Data			1									
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Operator										:		
Material												
Setup				,								
Other												
Process												
Supplier			İ			ł						
Training		<b>,</b>										
Unapproved												·
						AUL	T CATE	GORY				
Landii	ng Gear			_	General	_	7		<u> </u>	1	_	¬
	Bendi	-			Bend	<u> </u>	Grain		<u> </u>	Ovalized	_	Pressure/Forced
	_	Not Conce	entric to	o/s	BOM/Route	<u> </u>	Hardwa			Over/Under	<u> </u>	Temperature/Cure
	Cracks				Broken/Damaged	╙	1	on Incomplete		Part Incorre		Weld
		ed/Crimped			Burrs	<u>_</u>	4	ions Incomplete/l	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs	,			Contamination	$\vdash$	Mainte			Part Moved		
	_	reat	1~2	<u> </u>	Countersink	<u></u>	Mislabe		<u> </u>	Positioned V		¬₋.
	<b>—</b>	tion Strip ii	1 Tube		Cut Too Short	$\vdash$	Misread			Power Loss/	Surge	Other
		s in Bend			Drill Holes	$\vdash$	Offset					
	Torqu	e Waves in	Extrusio	n	Drawing	1	Out of C	Calibration				

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Finish

Folio

Work Ord September-23-				*107	7137*			Page 3
Item ID: Revision ID: Item Name:	D4001-3 Fitting			Accept	*N900040100	<b>★</b> Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date Reference:	9/23/13 e: 9/23/13	Start Qty: 4.00 Req'd Qty: 4.00	*4* *4*		Cust Item ID: Customer:			
Approvals:	Process P QC:	lan:	Date:	Tooling: SPC (Y/N):	Date:	Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center 1	ID	Operation Description OC21- Final Inspection	· Work Order Release	Set Up/ Run Hours		Accept Rej Qty Qty	_	Reject Insp. Number Stamp

0.00

Memo

\*150\*

Quality Control

W3-10-4

											DQA:	Da	te:	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORI	MANCE / UPDATE		QA Closed:	Da	te:	
			• • • • • • • • • • • • • • • • • •			1	_	T			QA Closed.	Da	ie.	
Work Ord	er.					DISPOSITION			AGAI	NST DE	PARTMENT	/PROCESS		
, , , , , , , , , , , , , , , , , , ,	••••	<del></del> -	1.1.1			Rework	1		Skid-tube Crosst	ube		Water Jet		Engineering
Part I	No.					Scrap	1	f	Machining Small	Fab	Pro	d. Eng. Coor.		Quality
	•					Use-as-is		Thern	noforming Finisl	~ -	Rec/Stor	re/Packaging		Other
NCR I	۷o.	· · · · · · · · · · · · · · · · · · ·				Work Order Update			Large Fab Compo	site		Supplier	Ш	
-				· · · · · · · · · · · · · · · · · · ·	Danavi		1	lmisial	Antina		Cian 0			·
Root		Date	Ston	Qty	1	ption of work order update or Non-conformance	1	Initial nief Eng	Action Description		Sign & Date	Verificatio	<u> </u>	QC Inspector
Cause Doc/Data		Date	Step	Qty		or Non-comormance	10	ilei ciig	Description		Date	Vermeatio		QC IIISPECTOI
Equip/Tooling	Н		i											
ł														
Operator Material	$\vdash$						1						1	
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Other														
Process			· ·											
Supplier		·	1											
Training														
Unapproved			<u> </u>			<u> </u>			·					
						F	AUI	LT CATE	GORY			· · · · · · · · · · · · · · · · · · ·		
Landi	ng (	1			_	General		,		_				•
	<u> </u>	Bending			<u> </u>	Bend	$\vdash$	Grain			Ovalized		$\sqcup$	Pressure/Forced
,	<u> </u>	Centre N	ot Conce	ntric to	o/s	BOM/Route		Hardwa		<u> </u>	Over/Under			Temperature/Cure
		Cracks			<u> </u>	Broken/Damaged	$\vdash$	<b>-i</b> '	ion Incomplete		Part Incorred		-	Weld
		Crushed/	'Crimped		ļ <u>.   </u>	Burrs	$\perp$	-	ions Incomplete/Unclear	L	Part Lost/Mi	ssing		Wrong Stock Pulled
	1	Cuffs				Contamination	1	Mainte	enance	1	Part Moved			

Mislabeled

Out of Calibration

Out of Sequence

Outside Dimensions

Misread

Offset

Positioned Wrong

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Heat Treat

Inspection Strip in Tube

Torque Waves in Extrusion

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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Picklist P	'n	n	t
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September-23-13 11:09:41 AM

Page 1

Work Order ID:

107137

Parent Item:

**Comments:** 

D4001-3

Parent Item Name:

Fitting

IPP rev A 09.12.23 new issue Prelim EC verified by:DD

IPP rev B 10.05.13 ecn10-562

**Start Date: 9/23/13** 

Start Qty: 4.00

FC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN832-6D UNION		Purchased	No	A A A A A A A A A A A A A A A A A A A		elaterary — .v laterary — ny 44.	Each	26.0000		4	ACTIVITY OF THE PROPERTY OF TH	THE WORLD CO.	
				Location		Loc Qty	Lo	c Code					
				ST324		26							
				12069 <b>≭</b> 12533		16 10			18		OAS	± 13	1001

Coul not pull mat! !

Required Date: 9/23/13

Required Qty: 4.00

										DQA:	Date:	
NCR:	/es / 1	lo			WORK ORDER NON-O	100	NFOR	MANCE / UP	DATE			
										QA Closed:	Date:	
Work Orde	nė.				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
WOIK Olde	=1.				Rework	ן ו		Skid-tube	Crosstube	1	Water Jet	Engineering
Part N	No.				Scrap	1		Machining	Small Fab	Pro	d. Eng. Coor.	Quality
					Use-as-is	1 1	`	noforming	Finishing	-1	re/Packaging	Other
NCR N	No.				Work Order Update	1		Large Fab	Composite		Supplier	
						_	<u> </u>					,
Root				Descri	ption of work order update	1	Initial	Act	tion	Sign &		
Cause	Da	te Step	Qty		or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling												
Operator			İ									
Material					×.	1.		.7%				
Setup				*		`						
Other						1						
Process												
Supplier						1						
Training												
Unapproved												
						AUI	LT CATE	GORY				
Landi	ng Gear				General		7		_	7	_	1
	Bend	•		_	Bend	$\perp$	Grain		_	Ovalized		Pressure/Forced
	Cent	e Not Conc	entric to	O/S	BOM/Route	$\perp$	Hardwa			Over/Under		Temperature/Cure
	Craci	(S			Broken/Damaged	$\perp$	- i	ion Incomplete		Part Incorre		Weld
	Crus	ned/Crimpe	d		Burrs		4	ions Incomplete/	Unclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte			Part Moved		
	Heat	Treat			Countersink		Mislabe	eled		Positioned V		1
	Inspe	ction Strip i	n Tube		Cut Too Short		Misread	d .		Power Loss/	Surge	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

DART AEROSPACE LTD	Work Order:	107137
Description: Fitting	Part Number:	D4001-3
Inspection Dwg: D4001 Rev: A		Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

FIRST ARTICLE INSPECTION CHECKLIST											
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments					
1.65	+/-0.030	70662	7		FK-04	Vern.					
0.813	+/-0.010	.814	7		6	t1					
0.938	+/-0.010	.935	7		L	h					
		-									
			-								
						•					
4											
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				` .							
1	0AS 44 4-8		0A0 40 9-8	<del>)</del>							
Measured by:	18-89	Audited by:	9-8	<b>3</b> /	Preliminary Ap	proval:					
Date:	13/09/30	Date:	13/10/0			Date:					

Rev	Date	Change	•	Revised	Þχ	Approved
Α	11.01.17	New Issue		KJ O	th	120
					71	



